Work Order ID 115186

Monday, March 17, 2014 2:50:02 PM

115186

Item ID: D3066-1
Revision ID:
Item Name: Spacer
Start Date: 4/15/14 **Start Qty:** 40.00 *40*
Required Date: 4/15/14 **Req'd Qty:** 40.00 *40*
Reference:

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** M **Date:** 14-03-19
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Run **Start** *NR1*
Stop *NR2*

Draw Nbr	Revision Nbr
D3066	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
100		0.00				40	0		JM14-04-9
Waterjet	**Memo**								
FLOW CNC Waterjet	1-Cut as per Dwg D3066 Dwg Rev: B Prog Rev: B 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110		0.00				40	0		JM14-04-9
QC	**Memo**								
Quality Control									
120	QC8- Inspect parts - second check	0.00	DAS 27 9-69						
120		0.00	4/4/9			40			
QC	**Memo**								
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
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☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
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☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130						40	7/8/14	9	
HandFinish	**Memo**	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140						40			DAS 19 9-89 14.04.09
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: WA-003	0.00							
150						40			DAS 19 9-89 14.04.09
Packaging	**Memo**	0.00							
Packaging	*** STOCK IN STEP CELL***								

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Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

14/4/9

14.04.09

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

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☐ Other

Picklist Print

Monday, March 17, 2014 2:50:01 PM

Work Order ID: 115186 *115186*

Parent Item: D3066-1 *D3066-1*

Parent Item Name: Spacer

Start Date: 4/15/14 **Required Date:** 4/15/14

Start Qty: 40.00 **Required Qty:** 40.00

Comments: IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF
IPP Rev:B Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	351.3800	0.0945	4			
M6061T6S.080									**			Jan 14-04-9	
6061-T6 .080 Sheet													

Location	Loc Qty	Loc Code
MAT021	351.38	
m126309	161.12	
m126350	14.26	
m128408	176	

26309.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

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DART AEROSPACE LTD	Work Order:	115186
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	0.129"	–		V	JLM05
0.708	+/-0.010	0.710"	–		V	
0.354	+/0.010	0.355	–		V	
0.354	+/0.010	0.354"	–		V	
2.250 (Pitch)	+/-0.005	2.252"	–		V	
16.450	+/0.010	16.450"	–		V	JLM09
0.080	+/-0.010	0.080"	–		V	

AS 27 9-89

Measured by:	JM
Date:	14-04-9

Audited by:	
Date:	14/4/9

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	

DQA: _____ Date: _____

DART AEROSPACE

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Unapproved	☐									

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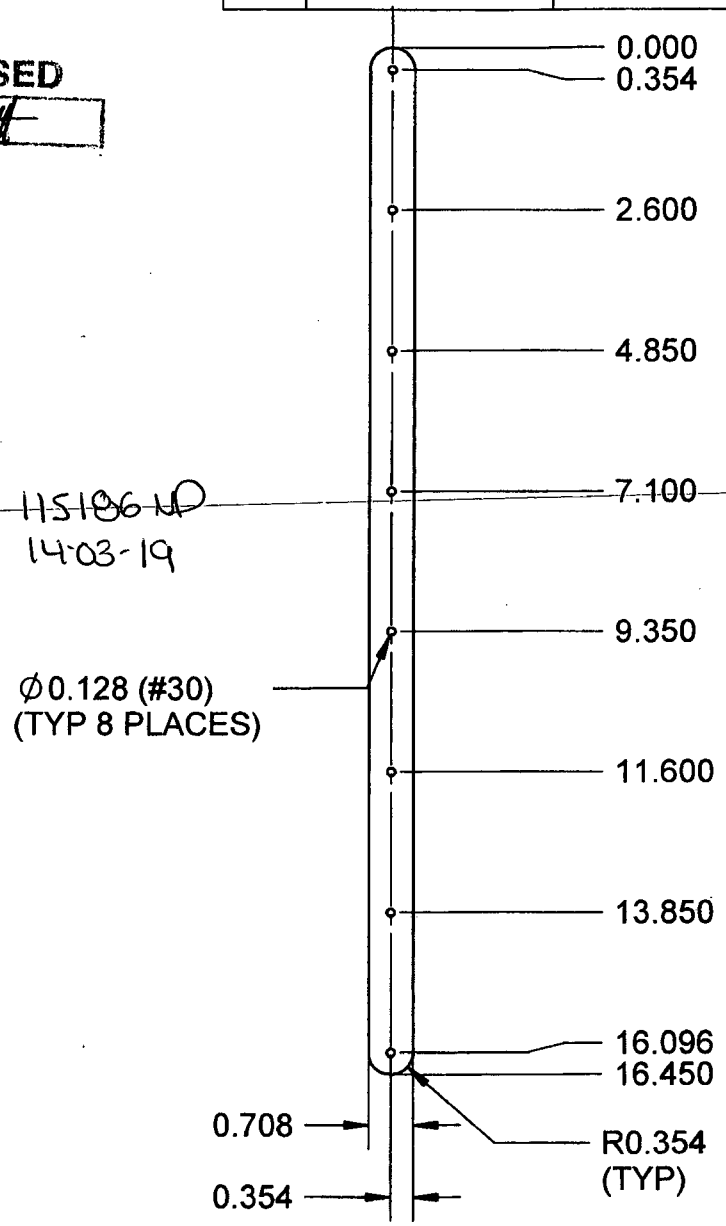
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☐ Other

DESIGN	DRAWN BY CB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SPACER	SCALE 1:3

A	02.09.11	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

RELEASED
06.06.20



115186 ND
14-03-19

D3066-1 SPACER

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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